

Date: Tuesday, 4/25/2006 1:54:22 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH
Job Number : 26836
Estimate Number : 10266
P.O. Number : NIA Part Number : D350636013
This Issue : 4/25/2006 S.O. No. : NIA Drawing Number : D2750 REV D
Prsht Rev. : NC Project Number : N/A
First Issue : NIA Type : LANDING GEAR Drawing Revision : D
Previous Run : 26100 Material : NIA
Due Date : 5/20/2006
Written By : See Comment Below Qty: 1 Um: Each
Checked & Approved By : 06.04.25
Comment : Est Rev: H 02.09.25 Rearranged procedure steps KJ
est rev I 06.03.30 Per rev. D dwg EC

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-013 CHG 002

KJ 06.05.10

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2600-3-Bent Extrusion (Bent) B26037

DP 06-5-1

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: 24672 BE 06-5-8

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8864 drilling holes labelled "B" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8864 and cut as per dwg D2750.

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Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes for Detail B using DT8330

5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" ***Make sure that wearplate holes are on bottom of tube*****

6-Open up holes of Detail A to 0.250" (total of 2 holes per side)

7- Countersink all fwd.wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

8-Countersink Detail A as per dwg D2750.

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *MI9101 BE 06-05-08*

10-Grind welds flush as per Dwg D2750 *BE 06-05-08*

5.0

QC5/9

WELD INSPECTION



2.5 06-05-09

PD 06-05-09



Comment: WELD INSPECTION

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Pm 06-05-18



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 06-05-23

8.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch: *B26921*

Pm 06-05-23

9.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: *B26307*

BE 06-05-25

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Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	D34905	CROSS BOLT SPACER
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: M26309 BE 06-05-25 (1)

11.0	D2743	Crossbolt Spacer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: B25838 BE 06-05-25 (1)

12.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

- 1-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750. fm'06-05-25 (1)
- 2-Open up holes "size X" (total of 4 holes per side) as per dwg D2750 fm'06-05-25 (1)
- 3-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750. fm'06-05-25 (1)
- 4-Chamfer holes of Detail V, Detail C, hole size "W" and "X" per dwg D2750 (welding instructions on sheet 5) fm'06-05-25 (1)
- 5-Deburr and blow out all chips from inside of tube fm'06-05-25 (1)
- 6-Bond web D2739 in place as per QSI 015
A/R Sikaflex-291 batch: m160901 fm'06-05-25 (1)
exp. date: 06-11-01
- 7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 5)
A/R Aluminum Rod batch: m19101 BE 06-05-25 (1)
- 8-Grind welds flush as per Dwg D2750 fm'06-05-25 (1)
- 9-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750 fm'06-05-25 (1)
- 10-Deburr holes fm'06-05-25 (1)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5/9

WELD INSPECTION



QC 9-5 DB 06-05-26

Jan 05-30 (1)



Comment: Inspect weld and work to Step 20

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

A.M 06-05-31 (1)

16.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Wearpad

Batch: *B24843-2 /*

17.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: *B25914 /*

18.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: *B24206 /*

19.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Wearplate

Batch: *B25841*

DL 06/05/31 (1)

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Job Number: 26836

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	D2745	Bushing
------	-------	---------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B24879

21.0	D3488041	BLADE FITTING ASSEMBLY, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B26189

22.0	D3492041	PLUG ASSEMBLY
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B26304

23.0	D3492045	PLUG ASSEMBLY
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: N/A

24.0	AN835A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M18576

25.0	AN960JD816	1/2" washer, Alum
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M6956

DL 06/05/31 ①

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Job Number: 26836

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS21083N8

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Nut

Batch: M19099

27.0

~~ALS41002225~~ NAS13053K B166

Insert



Comment: Qty.: ~~40.0000~~ Each(s)/Unit Total: ~~40.0000~~ Each(s)

Insert

Batch: M100199

28.0

AN960JD10L

Washer



Comment: Qty.: ~~42.0000~~ Each(s)/Unit Total: ~~42.0000~~ Each(s)

Washer

Batch: M18235

29.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)

Bolt

Batch: M100186

30.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M19522

31.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M19522

32.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch: M19417

19814 06 06/05/31 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 1:54:23 PM
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26836

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN8C35A

AN8-35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M18576

34.0

AN960C10L

washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

washer

Batch: M18822

35.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M100186

36.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M19185

37.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M100186

38.0

NAS1330S3KB166

INSERT



Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

INSERT

Batch: M100199

39.0

NAS1515H3L

WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

WASHER

Batch: M100186

06-05-31 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26836

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0	NAS1515H8L	WASHER
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

WASHER

Batch: M100187 ✓

41.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

2-Spray inside of tube with "LPS-3" batch: M100609

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

3-Coat all exposed fasteners with "LPS Procyon" batch: M17168

42.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

43.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

44.0	D2741	Blade
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: B25938 ✓

45.0	AN960C816L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M100186 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26836

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

46.0	MS21083C8	NUT
------	-----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: m100186 ✓

47.0	AN8C21A	BOLT
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: m100186 m100262 ✓

48.0	NAS1515H8L	WASHER
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: m100187 ✓

INSPECT 100% KITS FOR COMPLETENESS

49.0	QC4	
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Comment: INSPECT 100% KITS FOR COMPLETENESS

50.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

Rev D

51.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 06-06-01

C 206106101

48.1 D3493-1 WASHER X2 BATCH B26004

Rev D 06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
06-02-07

DESIGN <i>P/H</i>	DRAWN BY <i>P/H</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. D SHEET 1 OF 5
DATE 06.01.05		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133/9157	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
5	5	5	5	D2648-3	WEARPAD
1	1	1	1	D2656-13	WEARSHOE
1	1	1	1	D2656-35	WEARSHOE
1	1	1	1	D2746	WEARSHOE
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
2	2	2	2	AN8C21A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
4	4	4	4	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
3	3	3	3	MS21083C8	NUT
42	42	42	42	NAS1330S3KB166	INSERT
46	46	46	46	NAS1515H3L	WASHER
12	12	12	12	NAS1515H8L	WASHER

SHOP COPY
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NO. 26836

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DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D2750	REV. D SHEET 2 OF 5
DATE 06.01.05	TITLE 350 SKIDTUBE ASSEMBLY		SCALE NTS

RELEASED
06.02.07GENERAL NOTES:

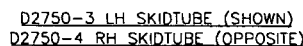
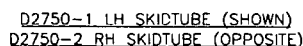
1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ($\emptyset 0.250$ - $\emptyset 0.257$) FOR WEARSHOE INSERTS. C'SINK $\emptyset 0.391 \times 100^\circ$ AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

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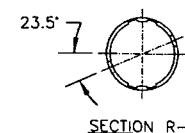
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WORK ORDER
NO. 26836

02.07 #

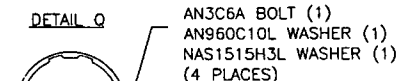
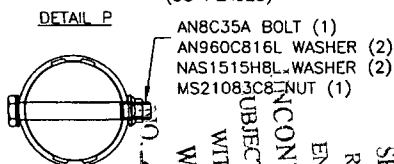
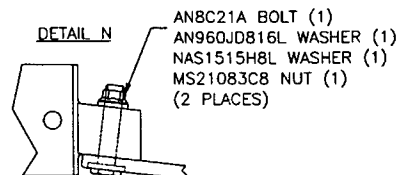
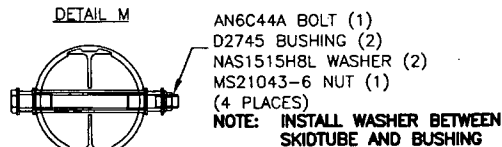
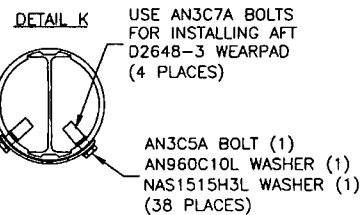
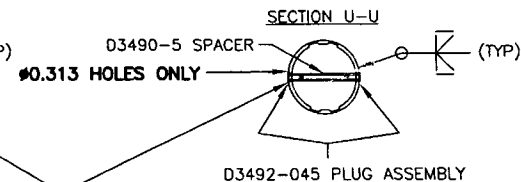
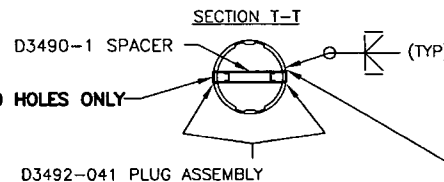
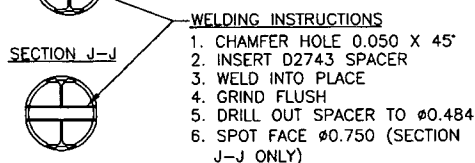
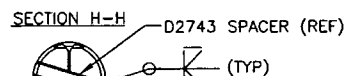
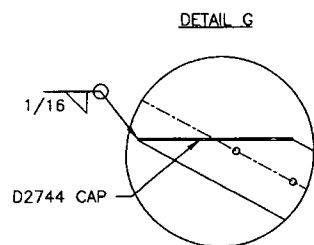
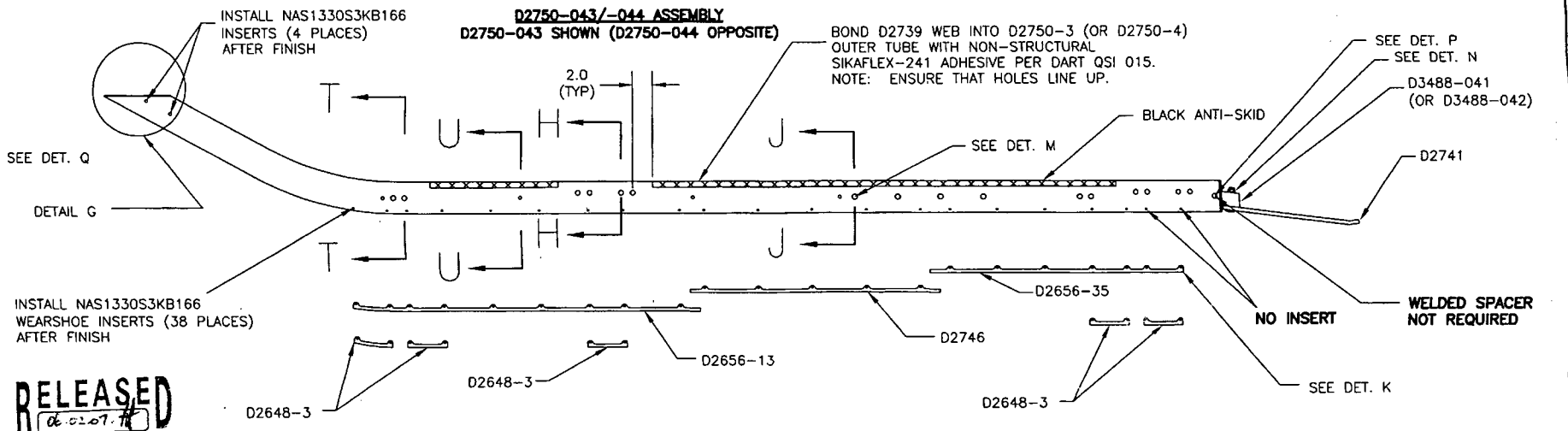


D2750-3/-4 AND D2750-1/-2 HAVE THE SAME SADDLE AND
GROUND HANDLING HOLES



DESIGN	PH	DRAWN BY	PH	 DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV.
				D2750	
				SHEET 3 OF 3	
DATE				TITLE	SCALE
06.01.05				350 SKIDTUBE ASSEMBLY	1:2

SHOP/COPY
RETURN TO
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WORK ORDER
NO. 26836

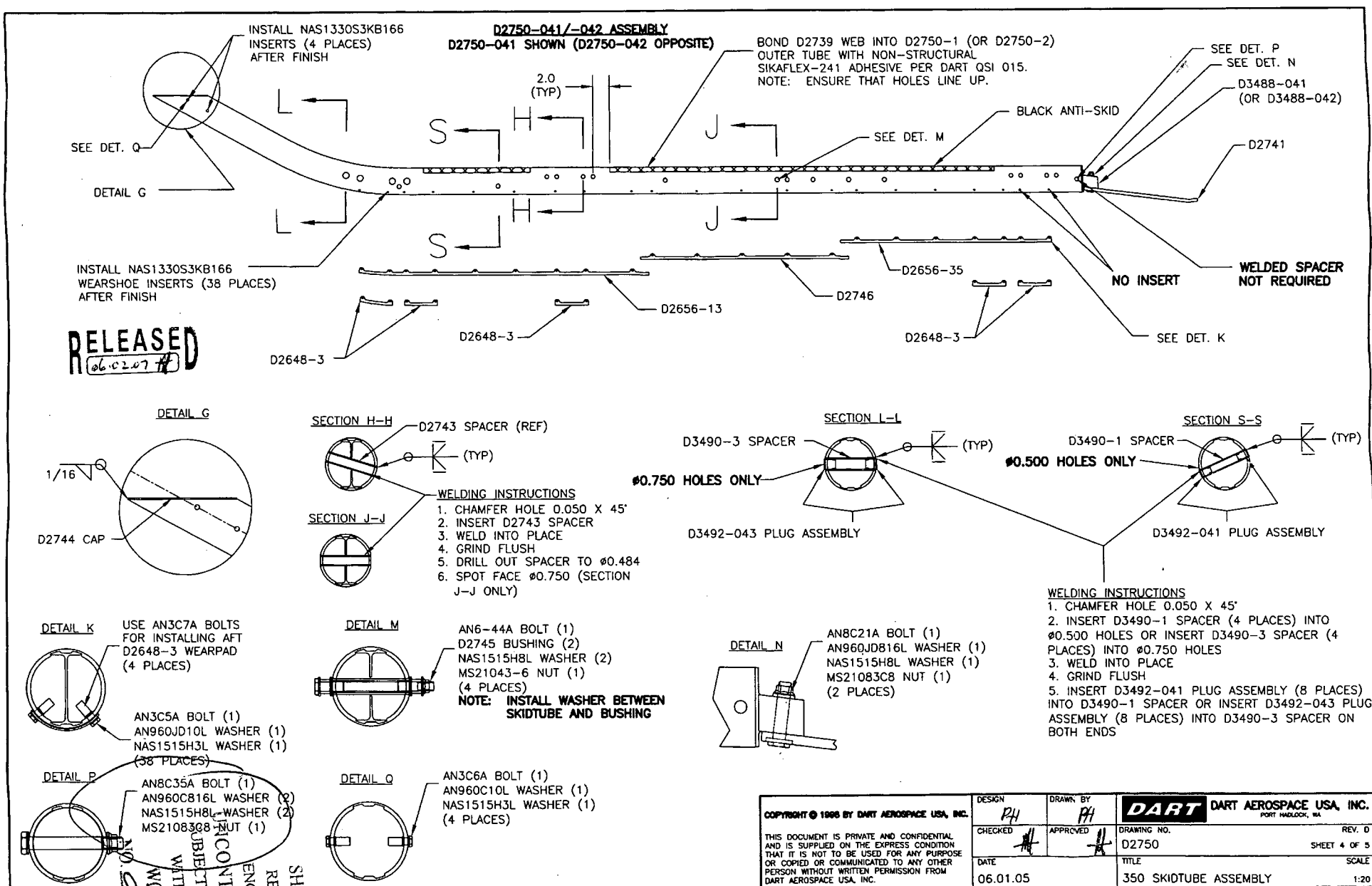


WELDING INSTRUCTIONS

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS

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CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. D
DATE	06.01.05			D2750	SHEET 5 OF 5
				TITLE	SCALE
				350 SKIDTUBE ASSEMBLY	1:20

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 WORK ORDER
 26826



AEROSPACE LTD		Work Order: 26836
Description: D350 sub tube Assembly LH		Part Number: D350-636-013
Inspection Dwg: D2750 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Detail A						
0.83	.030	.83				
2.770	.010	2.770				
Detail B						
1.180	.010	1.180				
3.150	.010	3.150				
1.180	.010	1.180				
Detail C						
1.180	.010	1.180				
3.150	.010	3.150				
1.180	.010	1.180				
Detail D						
1.720	.010	1.720				
3.940	.010	3.940				
1.720	.010	1.720				
.550	±.020	.550				
2.480	.010	2.480				
1.125	.010	1.125				
67.96	.030	67.96				
1.125	.010	1.125				
23.01	.030	23.01				

Doesn't Apply
to -013 or -014

All measurements
verified

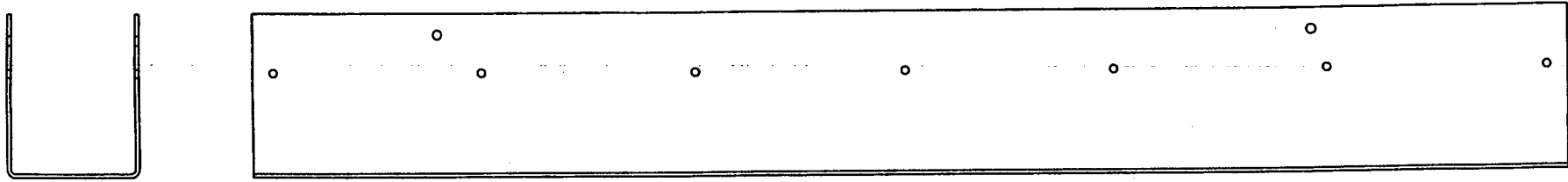
Measured by: DP	Audited by: J	Prototype Approval:
Date: 06-5-2	Date: 06-05-30	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

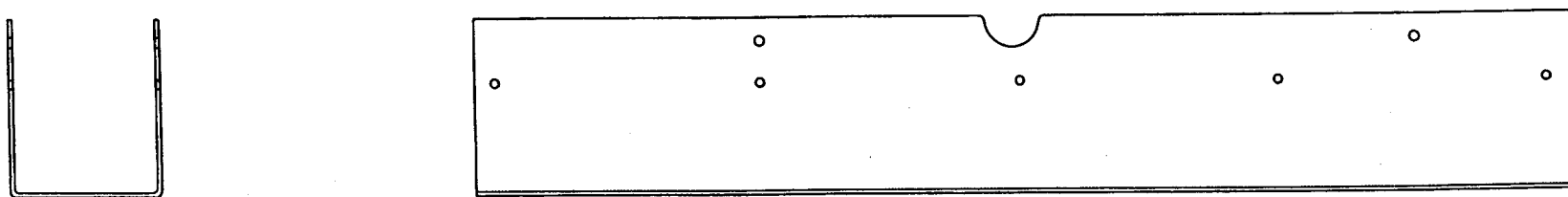
REFERENCE ONLY

TRI-BAG GIRTS

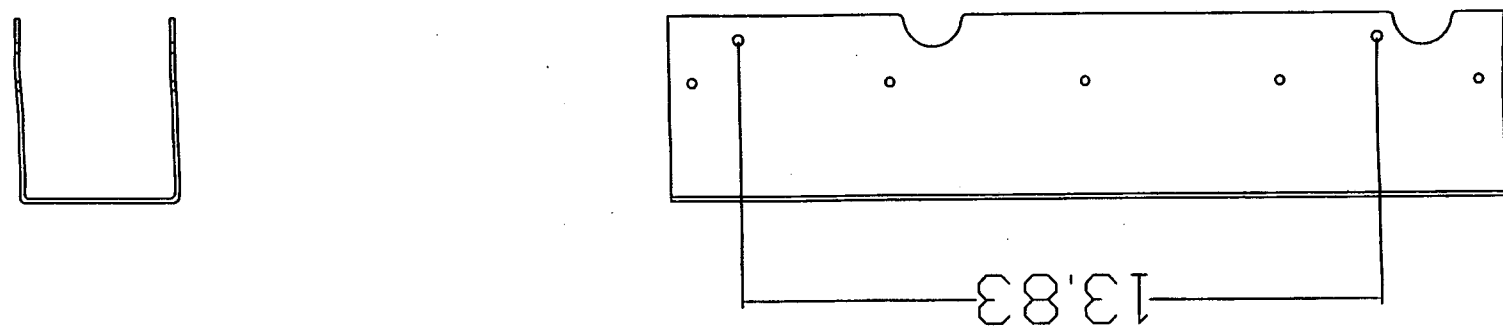
AFT FLOAT



MID FLOAT



FWD FLOAT



Peter Hum

From: David Shepherd [davids@dartaero.com]
Sent: Wednesday, May 31, 2006 4:13 PM
To: Peter Hum
Subject: Re: bolt securing aft blade fitting

Acceptable substitution.

----- Original Message -----

From: "Peter Hum" <phum@dartaero.com>
To: "David Shepherd (E-mail)" <davids@dartaero.com>
Cc: "Serge Shahbazian (E-mail)" <sshahbazian@dartaero.com>
Sent: Wednesday, May 31, 2006 2:06 PM
Subject: bolt securing aft blade fitting

> Hi David,
>
> The AN8C35A bolt (qty 1 per side) that is used on the D350-636-013/-014
skid
> is NOT available in stock/delivery.
>
> We placed an order for this part on Apr 1st and still haven't received
this
> part.
>
> If required would it be acceptable to use AN8-35A bolt as a replacement?
>
> Peter
>
>

Dan Stow

From: David Shepherd [davids@dartaero.com]
Sent: Friday, May 05, 2006 11:06 AM
To: Dan Stow
Subject: Re: D350-636-013B26836

I think these holes are sufficiently far away from the good holes that they can be filled with weld and ground flush.

David

----- Original Message -----

From: "Dan Stow" <dstow@dartaero.com>
To: "'David Shepherd'" <davids@dartaero.com>
Sent: Friday, May 05, 2006 8:12 AM
Subject: D350-636-013B26836

>
> David,
>
> The wrong section of the drill jig was used to drill the saddle holes.
This
> is a first off and the LH/RH jigs were mislabeled, they are now correctly
> identified. Is it acceptable to fill the four 0.125" holes with weld and
> grind flush?
>
> Dan
>

C. FLOAT INSTALLATION

1. For MID floats to fit over skid tube, remove ground handling bolts from skid tube according to figure 6.
2. For FWD floats to fit over skid tube, remove bolts from skid tube according to fig 6. Fill thread with F/N 27 or Proseal 890 and install OEM cap.
3. Place float (F/N 1, 2, 3, 4, 5, and 6) on skid and locate per Figure 6. Match drill through the float girt with .190 drill. Remove the float and open holes to .318 - .328 diameter. Use Unibit #2 for ease of drilling. Dress holes and apply zinc chromate putty or Mastinox.

REFERENCE ONLY

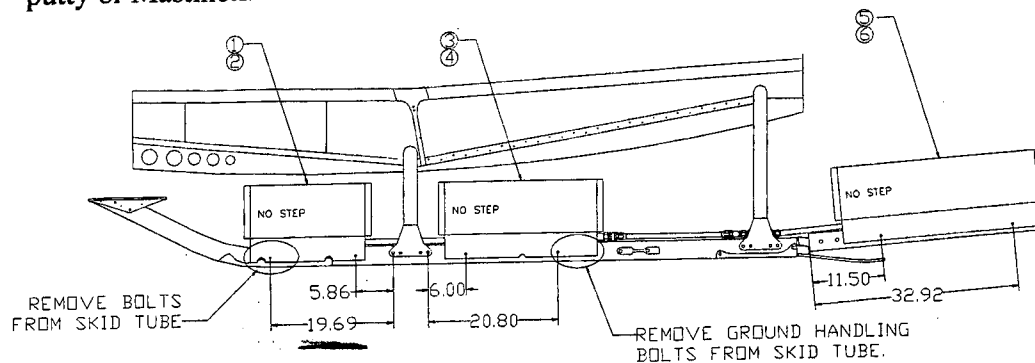
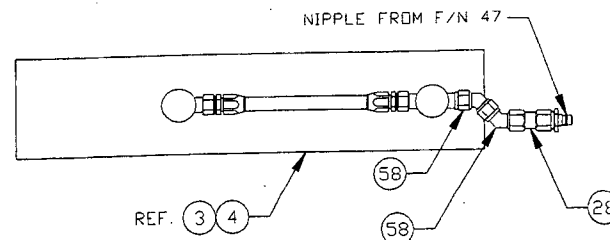


Figure 6.

4. Insert spacer (F/N 43 for fwd and mid floats and F/N 41 for aft floats) in holes drilled. See figure 8.
5. Connect hoses (F/N 55) to fwd floats.
6. Connect two 45° elbows (F/N 58) to each mid float (F/N 3 and 4). Connect union (F/N 28) to 45° elbow (F/N 58). Connect quick disconnect nipple from hose (F/N 47) to 45° elbow (F/N 58). See figure 7.



R.H. SHOWN FROM BOTTOM
L.H. OPPOSITE

Peter Hum

From: Peggy McDonald [pmcdonald@dartaero.com]
Sent: Thursday, June 01, 2006 10:26 AM
To: jmurdoch@dartaero.com
Cc: 'David Shepherd'; 'Peter Hum'; 'Bill Beckett'
Subject: APICAL FLOAT SKIDTUBES

Hi Jason,

In order not to delay this shipment of the APICAL float compatible skidtubes, the skidtubes were shipped without plugs in the holes that will be used for the Tri-Bag Float Install. I discussed this with Peter and David prior to contacting the customer. I advised the customer (Acro Heli-Pro) and they have accepted to receive these skidtubes as explained, due to a delivery deadline.

I hope this information is helpful. Contact me if you have any questions or concerns.

Peggy

DART

Invoice

1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Date	Page
Jul 24, 2006	1

Invoice Number
IN000002364

Due Date	Aug 23, 2006
----------	--------------

Sold To:

Dart Helicopters Services
5493 Highway 11E
Suite 2
Piney Flats, TN 37686
United States

Ship To:

Acrohelipro
#101B - 5947 - 206A Street
Langly, BC V3A 8M1
Canada

Order No.	Order Date	Customer No.	Salesperson	PO Number	Ship Via	Terms
OR000001918	Jul 17, 2006	CU-DAR001	HMAHON	8002881	Origin	NET30

Qty. Ord.	Qty. Shp.	Qty. B/O	Item Number	Description	List Price	Customer Discount	UOM	Extended Price
1.0000	.0000	0.0000	D350-636-011	Skidtube LH B/N27499 Apical Cylindrical Comp 27499	4,495.00	-100%	Each	0.00
1.0000	.0000	0.0000	D350-636-012	Skidtube RH B/N27668 Apical Cylindrical Comp 27668	4,495.00	-100%	Each	0.00

*MAY HAVE
KEPT KIT
PARTIAL KIT
B 26836*

Comments:**Tax summary:**

GSTUS 0.00

Subtotal	0.00
Total sales tax	0.00
Total amount	0.00
Less payment	0.00
Less pmt. disc	0.00
Amount due	0.00

Date: Wednesday, 06/09/2006 12:59:18 PM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D350636011/-012
Job Number	: 28429		
Estimate Number	: 10804		
P.O. Number	: <i>N/A</i>	Part Number	: Z_CUSTOM
This Issue	: 06/09/2006 S.O. No. : <i>N/A</i>	Drawing Number	: SCRAP-RTN 499
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : OVERHEAD	Drawing Revision	: <i>N/A</i>
Previous Run	: 00015	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 13/09/2006 Qty: 2 Um: Each
Checked & Approved By	: _____		
Comment	: _____		

Additional Product

Job Number:



original B -012-7
011-7 326092

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT RTN 499

06-09-07 (2)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
SCRAP TUBES AND HARDWARE

original B #5 -013 626836 -014 626837

6-9-7 (2)

3.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06-09-26 (2)

Job Completion



06-09-26